



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11631-3G-07

Job Sheet 198072



Part No: RBW6305G11631-3G-07

Job Qty: 1 pcs

Part Name: Threaded Shaft

6 pcs.

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G11631-3G Rev. D IPP Rev. A 18.05.08 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	1 pcs	9/20/19	9/20/19	1.50	0.17	SL-154 - 1		JB 19.08.30
150	QC 2	1 pcs	9/20/19	9/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB - 19.08.30
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S210660

Part: RBW6305G11631-3G-07

Job No: 198072

Serial No/Batch: S210660

Revision: D

Inspector:

Exp Date:

				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
160	QC 8	1 pcs	9/20/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
170	Outsource - 13 - Zinc Plating	1 pcs	9/20/19	0.00 0.00	GROO2
180	Packaging 2-1 - Receive - B4B	1 pcs	9/20/19	0.00 0.00	2019-09-03
					Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B

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				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	1 pcs	9/20/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 81
				QC 6 - 40	9-89
				QC 6 - 81	SEP 11 2019
200 Packaging 3-1 - Stock - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	1 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS 70
				QC 21 - SA - 53	9-89

close work only

Part Op 120 - SL-154 (MORI SL-154 LATHE) ***NOTE***34" Makes 4pcs. 1-Machine as per folio FC106 FOLIO REV:
 Descriptions: AA DWG REV: D 2-Deburr
 150 - (QC2- Inspect parts off machine FAI/FAIB)
 160 - (QC8- Inspect parts - second check)
 170 - Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O 44400 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required
 180 - (Receive & Inspect for Damage & Mat'l Certs) Receive
 190 - (QC6- All purchased or subcontracted products)
 200 - (Identify as per dwg & Stock Location: _____) IDENTIFY AND STOCK
 210 - (QC21- Final Inspection - Work Order Release)

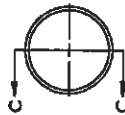
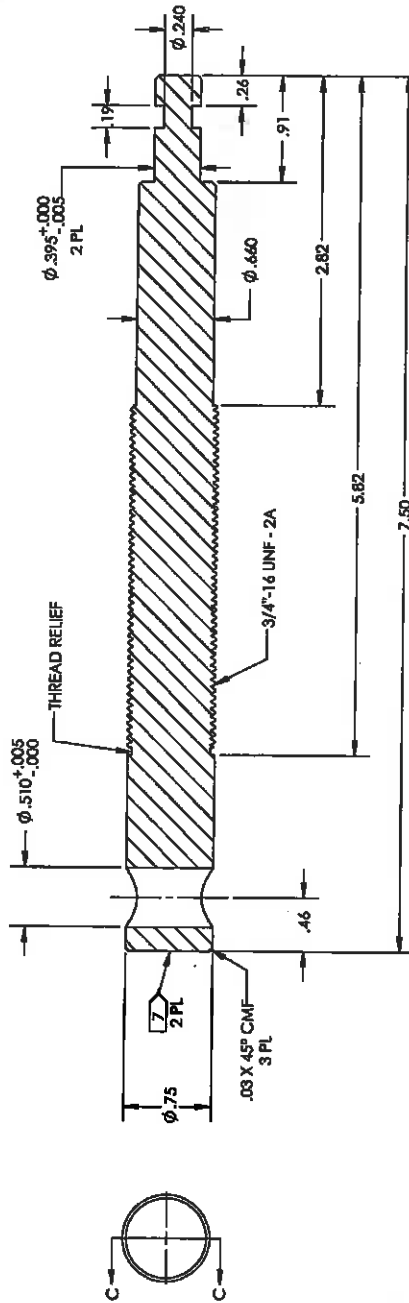
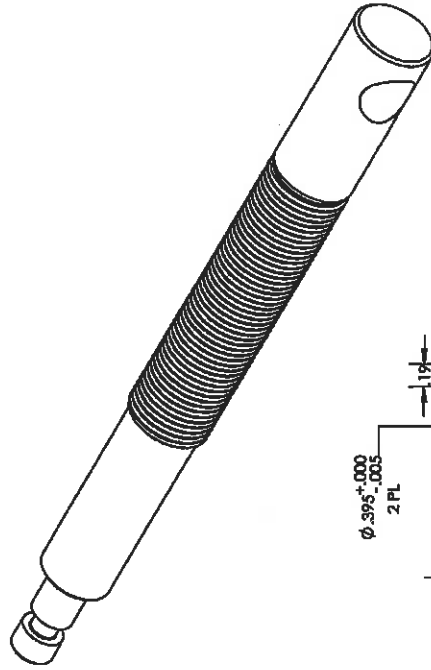
GA 141 E

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.750	AISI 4140 Quenched & Tempered Steel Round Bar 0.750" Dia.	.6250 ft (.625 ea)	120-SL-154 - 1	S093067 S200821
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	MT-4140QT-R0.750	1	5	0
Part Specifications				
Specifications could not be found.				

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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
D	CAD PLATE YELLOW CHANGED FOR ZINC PLATE TEMPLATE UPDATED, DIMENSION .680 ADDED, THREAD RELIEF ADDED, DIMENSION .50 CHANGED FOR .510 +.005/-0	18-039	18.2.8	VM	ML

SHOP COPY
RETURN TO
ENGINEERING COPY
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19-8012-1405
19-07-22



RBW6305G11631-3G-07 THREADED SHAFT

SECTION C-C

PART
AEROSPACE
Technology, Ontario, Canada

THREADED SHAFT

PART NO.	RBW6305G11631-3G-07	REV.	D
QUANTITY	1	DATE	
DESCRIPTION	THREADED SHAFT		
ENGINEER	VM	DATE	
CHECKED BY	VM	DATE	
APPROVED BY	ML	DATE	
SCALE	1:1	SHEET	1 OF 1
THIS DOCUMENT IS PREPARED BY THE PART OWNER AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM THE PART OWNER.			

- NOTES:
- 1) MATERIAL: AISI 4140M142 (Rc 28-32)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ZINC PLATE
 - 4) SPEC: ASTM B633 TYPE 2 CLASS 2
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A
 - 7) CENTER DRILL IS ACCEPTABLE

DART AEROSPACE LTD		Work Order:	1000000000
Description: Threaded Shaft		Part Number:	RBW6305G11631
Inspection Dwg:	Rev: D		Page 1 of 1

RBW6305G11631-3G-07 INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .75	±.010	.740	✓		Vernier	JB-01
Ø .660	±.005	.659 ^B	✓		mic	CNC-22
Ø .395	+ ^{.000} - _{.005}	.392 ^B	✓		mic	CNC-22
Ø .240	±.005	.239	✓		Blade mic	LB-insp6
Ø .510	+ ^{.005} - _{.005}	.511	✓		vernier	JB-01
7.50	±.010	7.501	✓		vernier	JB-01
5.82	±.010	5.820	✓		vernier	JB-01
2.82	±.010	2.820	✓		vernier	JB-01
.91	±.010	.910	✓		vernier	JB-01
.46	±.010	.461	✓		vernier	JB-01
.26	±.010	.262	✓		vernier	JB-01
.19	±.010	.189	✓		vernier	JB-01
.03 x 45°	±.010 x .5°	.031 x 45°	✓		optical comp.	
3/4-16 UNF 2A	-	3/4-16 UNF	✓		Nut	3/4-16 UNF
major Ø	.748 ^S / .739 ^I	.740 ^B	✓		mic	CNC-22
minor Ø	.773 ^S / .768 ^B	.771 ^I	✓		mic	CNC-22

Measured by:	JB	Checked by:		QC Inspector:	
Date:	19.08.30	Date:	19/08/31	Date:	

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044400



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044400

PO Date: 9/3/19

Due Date: 9/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

EMMAILED
2019-09-04

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196961	RBW109-3501-03-17-1	Weldment -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/11/19	2 pcs	0 pcs	2 pcs	\$1.10/pcs	\$2.20
				X2		SEP 10 2019				DP	
	196961-A	5209494		Firmed	X4	9/11/19	4 pcs	0 pcs	4 pcs	\$1.10/pcs	\$4.40
						SEP 10 2019				DP	
Sub Total:							6	0	6		\$6.60

2	99390	RBW6405G04132-3G-7	Slider -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/11/19	6 pcs	0 pcs	6 pcs	\$2.85/pcs	\$17.10
				X6		SEP 10 2019				DP	
							5209688				



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PURCHASE ORDER

POHB044400



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	196558	RBW6705G02231-3G	Rigging Pin Assembly N3 -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	-	9/11/19	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00
				X10		SEP 10 2019					DP
							5194740				
4	198076	RBW6305G11731-3G-05	Lug (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	9/11/19	12 pcs	0 pcs	12 pcs	\$1.65/pcs	\$19.80
				X12		SEP 10 2019					DP
							5210184				
5	198072	RBW6305G11631-3G-07	Threaded Shaft Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	9/11/19	6 pcs	0 pcs	6 pcs	\$4.55/pcs	\$27.30
				X6		SEP 10 2019					DP
							5210660				

Grand Total: \$145.80



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PURCHASE ORDER

POHB044400



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/4/19 10:03 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022087-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022087 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

SEP 09 2019

DART AEROSPACE LTD.

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
06-Sep-2019		Jigar Patel			POHB044400			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3501-03-17-1 Rev.	RBW109-3501-03-17-1 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 " THICKNESS	ZINC CH	2	2	0	0	0
2	RBW109-3501-03-17-1 Rev.	RBW109-3501-03-17-1 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 " THICKNESS	ZINC CH	4	4	0	0	0
3	RBW6405G04132-3G-7 Rev.	RBW6405G04132-3G-7 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0
4	RBW6705G02231-3G Rev.	RBW6705G02231-3G ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 " THICKNESS	ZINC CH	10	10	0	0	0
5	RBW6305G11731-3G-05 Rev.	RBW6305G11731-3G-05 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	12	12	0	0	0
6	RBW6305G11631-3G-07 Rev.	RBW6305G11631-3G-07 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0

RECEIVED

Notes Additionnelles / Additional Notes

SEP 09 2019

2 Boxes

DART AEROSPACE LTD.

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

SEP 09 2019

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.